

Date: Monday, 02/06/2008 12:50:05 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SINGLE MIRROR ASSEMBLY
Job Number :	39398		
Estimate Number :	12277		
P.O. Number :		Part Number :	D206558041
This Issue :	02/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN206-558 / D2065
First Issue :	22/05/2008	Project Number :	N/A
Previous Run :	36587	Drawing Revision :	C / B1
	Type :	Material :	
	SMALL / MED FAB	Due Date :	06/06/2008
Written By :		Qty :	10
Checked & Approved By :		Um :	Each
Comment :	Est. F 02.09.19 Re-format; Incorporated D2065 KJ Est Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD verified:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.6.03

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D206-558-041 CHG006

2.0	M304TR0500W035	304 RD Tube .500 x .035W
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**Comment:** Qty.: 1.7500 f(s)/Unit Total: 14.0003 f(s)

304 RD Tube .500 x .035W

304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012

(M04TR0.500W035)

Identify as D2065.

Batch 108215

Note: 1 end only

SB 07/06/04

3.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Punch 1/2" OD x .035" Wall AISI

SIS 08/06/04

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Cut to length as per Dwg D2065

Bend as per Dwg D2065 and template D2065T1

Flatten the end on Hydraulic press using Dt 8545

Drill 00.188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig

Deburr.

FF 08206-11

FF 08206-20

08/06/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-558-041 PAR #: _____ Fault Category: Engineering Design NCR: Yes No DQA: D Date: 08/07/03
 QA: N/C Closed: _____ Date: _____

NCR: <u>39398</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/03	#	Durrim QC inspection it was noticed that the hole location .064" was off. From looking at the D2057 Plug it was found that it was under Review	<u>OS1012</u>	AFTER Talking with Mike P. it was decided to Scrap and Destroy all 10 parts. Due to	<u>PH</u> 08/06/11	<u>OS10660</u>	<u>OS1012</u>	<u>OS10614</u>
		to decrease the Dist Dia. of the Plug to allow for .049" wall mat. All 10 parts were made with .035" wall. After Talking with Peter Hum it was found that the D206-558-041 was suspected	<u>OS1012</u>	the wall thickness. and replace with 304 RD Tube .500" x .049" B# <u>N103 324</u>	<u>SP</u> 08/06/20 <u>SP</u> 08/06/20	<u>OS10660</u>	<u>OS1012</u>	<u>OS10614</u>
		to be put under Review for the mat. wall thickness.	<u>OS1012</u>	*Put drawing under Review for Eng deviation for replacing parts.	<u>PH</u> 08.06.20	<u>OS10660</u>	<u>OS1012</u>	<u>OS10614</u>

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 12:50:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SINGLE MIRROR ASSEMBLY

Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/06/20 (X10)

6.0

POWDER COATING

POWDER COATING



M1102316



(10X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

1:20

OVEN TEMPERATURE:

320 °F

FINISH TIME:

1:50

M-1 08/06/20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8 08/06/20 (X10)

8.0

D2011101

6" Mirror



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8.0000~~ 10 Each(s)

Mirror 6"

Pick:

Qty Part Number

Description

Batch

1 D2011-101

Mirror

B39555

AS 08/06/23 (X10)

9.0

D2052

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~16.0000~~ 20 Each(s)

Bracket

Pick:

Qty Part Number

Description

Batch

2 D2052

Bracket

30017

AS 08/06/23 (X10)

10.0

D2054

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~16.0000~~ 20 Each(s)

Bushing - Delrin

Pick:

Qty Part Number

Description

Batch

2 D2054

Bushing

B3219 x1 B39433 x19

AS 08/06/23 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2055

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8.0000~~ 10 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

1 D2055 Clamp

B34365

JS 08/06/23 (X10)

12.0

D2056

Bell Crank



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bell Crank Assembly

Pick:

Qty Part Number Description Batch

1 D2056 Bellcrank

B39434

JS 08/06/26

13.0

D2057

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8.0000~~ 10 Each(s)

Plug

Pick:

Qty Part Number Description Batch

1 D2057 Plug

34366

JS 05/06/23 (X10)

14.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~32.0000~~ 40 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 AN960JD10 Washer

M108077

JS 08/06/23 (X10)

15.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~16.0000~~ 20 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21042L3 Nut
or MS21042-3

M67605

JS 08/06/23 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~16.0000~~ 20.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-18 Screw

M106112 x15 M108114 x5 AS 08/06/23 (X10)

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-558

EP 08/06/26 (10)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/26 (X10)

19.0

D2053

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2053

Bracket

B38531 (X10)

AS 08/06/23 (X10)

20.0

D37781

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bracket

batch:

B39283 (X10)

AS 08/06/23 (X10)

21.0

D2067

Connector



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Connector

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2067

Connector

B37483 x1
B39558 (X9)

AS 08/06/23 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D2071

Cable Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cable Assembly

Pick: Packing Kit

Qty Part Number Description Batch
1 D2071 Cable

B39559 x4
B38289 x3 B38289 x3

AS 08/06/23 (X10)

23.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch
4 AN3-4A Bolt

M103641 x12 M103641 x20

AS 08/06/23 (X10)

24.0

AN5261032R9

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Screw

Pick: Packing Kit

Qty Part Number Description Batch
4 AN526-1032R9 Screw

or AN526C1032R9

M12241 x12
M12241

Bar code not in comp

AS 08/06/23 (X10)

25.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch:

M107644 x3 M107665 x7

AS 08/06/23 (X10)

26.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch
4 AN960JD10L Washer

M104885 x12 M104885 x28

AS 08/06/23 (X10)

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Drawing Name: SINGLE MIRROR ASSEMBLY

Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21919DG5

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21919DG5 Clamp
or MS21919WDG5

M107591 x 6

~~M11325 x 14~~
M107591 x 14

JS 08/06/23 (10)

28.0

MS354899

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Grommet

Pick: Packing Kit

Qty Part Number Description Batch

1 MS35489-9 Grommet

M9619 x 3

M9619 x 7

JS 08/06/23 (10)

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08-06-27 (10)

Kits in box

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-558-041

Location:

PPP Rev:

RENG

8/4/27

(80x)

SD

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/01



Job Completion



mf 08-06-28

Date: Thursday, 22/05/2008 1:38:39 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SINGLE MIRROR ASSEMBLY	
Job Number : 39398		
Estimate Number : 12277		
P.O. Number :	Part Number : D206558041	
This Issue : 22/05/2008 S.O. No. :	Drawing Number : IIN206-558 / D2065	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C / B1	
Previous Run : 36587	Material :	
Written By :	Due Date : 06/06/2008	Qty:  Um: Each
Checked & Approved By : <u>JL008.S.22</u>		
Comment : Est. F 02.09.19 Re-format; Incorporated D2065 KJ Est Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD verified:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D206-558-041 CHG006

2.0	M304TR0500W035	304 RD Tube .500 x .035W
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**Comment:** Qty.: 1.7500 f(s)/Unit Total : 14.0003 f(s)

304 RD Tube .500x .035W

304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012

(M04TR0.500W035)

Identify as D2065.

Batch _____

Note: 1 end only

path from sfl

3.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Punch 1/2" OD x .035 " Wall AISI

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Cut to length as per Dwg D2065

Bend as per Dwg D2065 and template D2065T1

Flatten the end on Hydraulic press using Dt 8545

Drill 00.188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig.

Deburr.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/05/2008 1:38:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SINGLE MIRROR ASSEMBLY

Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D2011101

6" Mirror



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mirror 6"

Pick:

Qty Part Number Description Batch

1 D2011-101 Mirror ~~38288~~

SD

9.0

D2052

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bracket

Pick:

Qty Part Number Description Batch

2 D2052 Bracket ~~17500~~

W

SD

10.0

D2054

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing - Delrin

Pick:

Qty Part Number Description Batch

2 D2054 Bushing ~~21219~~

8/5/22

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SINGLE MIRROR ASSEMBLY

Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2055

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clamp

Pick:

Qty Part Number Description

Batch

1 D2055 Clamp

34365

SP

12.0

D2056

Bell Crank



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bell Crank Assembly

Pick:

Qty Part Number Description

Batch

1 D2056 Bellcrank

37629

37727

SP

13.0

D2057

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Plug

Pick:

Qty Part Number Description

Batch

1 D2057 Plug

34366

SP

14.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

4 AN960JD10 Washer

107199

SP

15.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick:

Qty Part Number Description

Batch

2 MS21042L3 Nut
or MS21042-3

107644

8/5/22

3x

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS27039118

Screw



3x

Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-18 Screw

106412

8/5/22

sc

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-558

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.0

D2053

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2053 Bracket

35362

20.0

D37781

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bracket

batch:

21.0

D2067

Connector



3x

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Connector

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2067

Connector

37483

8/5/22

sc

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 39398

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D2071

Cable Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cable Assembly

Pick: Packing Kit

Qty Part Number Description Batch
1 D2071 Cable 38289

sp

23.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch
4 AN3-4A Bolt 103641

sp

24.0

AN5261032R9

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Screw

Pick: Packing Kit

Qty Part Number Description Batch
4 AN526-1032R9 Screw 12241
or AN526C1032R9

*

30

25.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: 107644

sp

26.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch
4 AN960JD10L Washer 104885

8/5/22

sp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21919DG5

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21919DG5 Clamp

or MS21919WDG5

107591

sq

28.0

MS354899

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Grommet

Pick: Packing Kit

Qty Part Number Description Batch

1 MS35489-9 Grommet

96A

8/5/22

sq

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-558-041

Location: _____

PPP Rev: _____

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

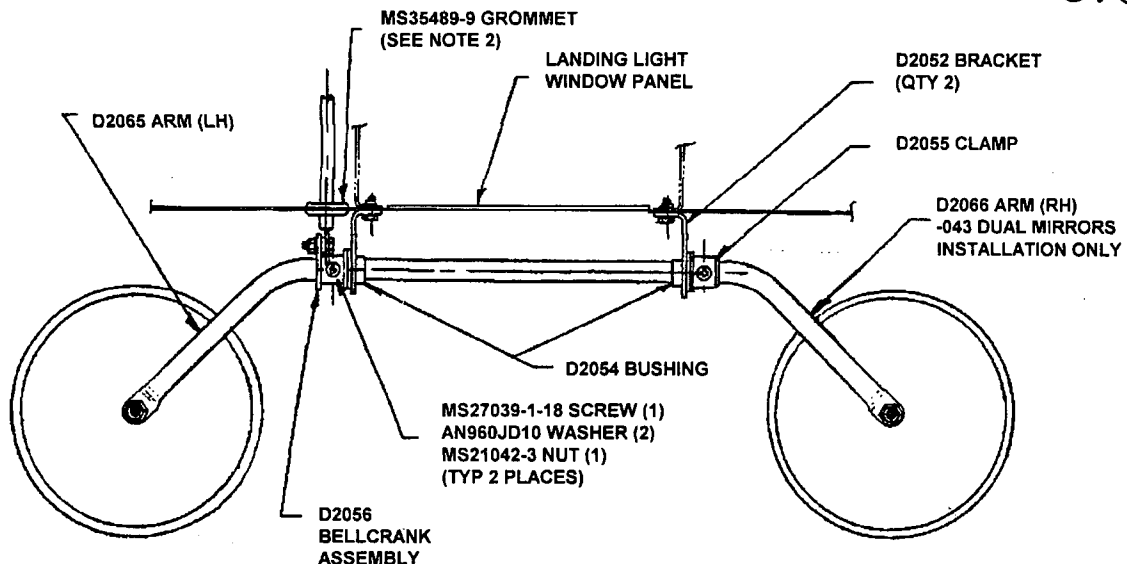
NOTE: Date & initial all entries

3.0 CARGO MIRROR INSTALLATION

Install the Cargo Mirror as follows:

1. Install D206-558-041/-043 cargo mirror assembly using AN3-4A bolts and AN960JD10L washers. Pickup existing anchor nuts in 4 places.
2. Install D2067 connector onto D2056 bellcrank assembly to locate hole for MS35489-9 grommet. With the mirror in the deployed position, mark and drill $\varnothing 0.125"$ (3.2mm) hole in landing light window panel where the grommet should be located. Open pilot hole to $\varnothing 0.563"$ (14.3mm). Install grommet.
3. Install D2053 bracket using AN526-1032R9 screws. Pickup on existing anchor nuts.
4. Position D2071 cable as shown. Install MS21919DG5 clamps using AN526-1032R9 screws where required. Pickup existing rivnuts or anchor nuts if available.
5. Install D2071 control cable using D2067 connector. Connector should rotate freely in bellcrank when MS21042-3 nut is torqued and cable clamped

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**Figure 2: – View A: Looking Aft.
(D206-558-043 Mirror Shown)**

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Revision: **C**

Date: 01.10.03

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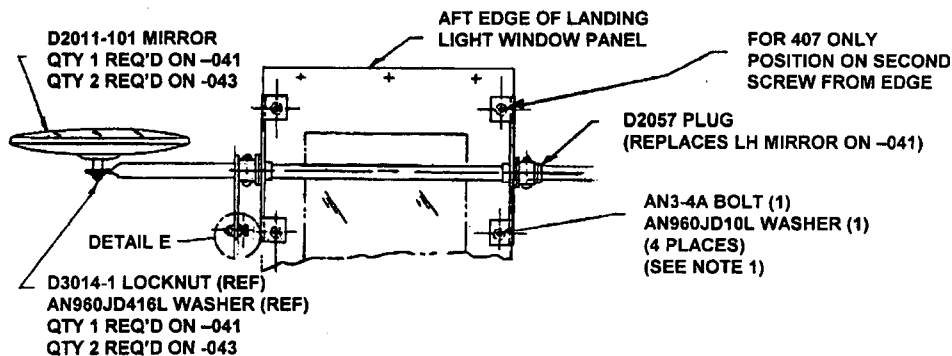


Figure 3: - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

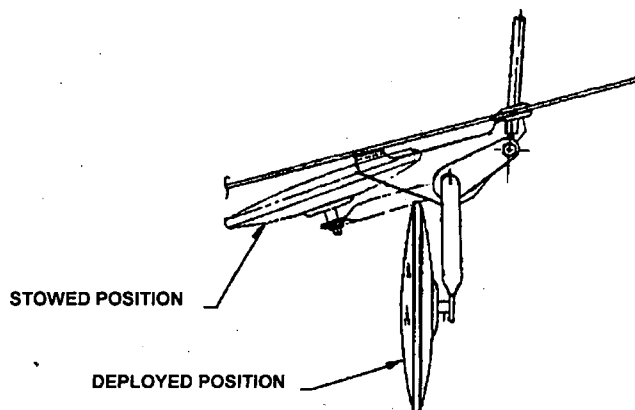


Figure 4: - Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

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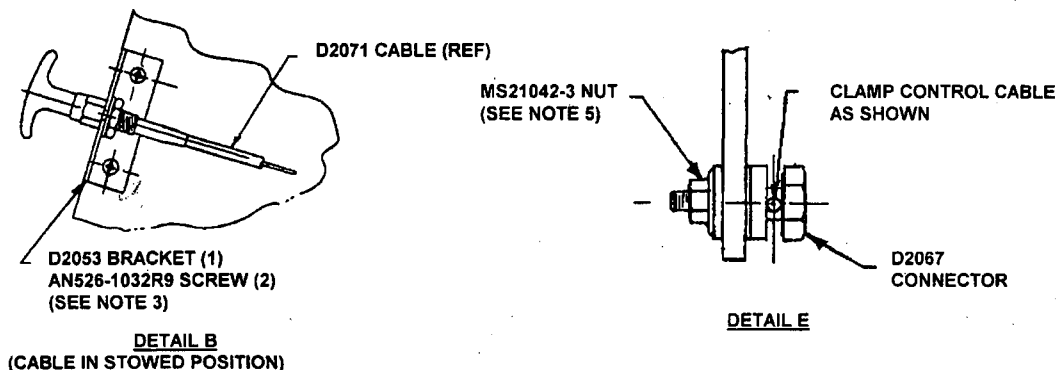


Figure 5: - Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041 Bell 206A/B/L/L1/L3/L4 Bell 407	2.4 lb 1.09 Kg	+5.0 in +0.13 m	+12.0 in-lb +0.14 m-Kg	+14.8 in +0.38 m	+35.5 in-lb +0.41 m-Kg
D206-558-043 Bell 206A/B/L/L1/L3/L4 Bell 407	3.0 lb 1.36 Kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-Kg	+14.8 in +0.38 m	+44.4 in-lb +0.52 m-Kg

5.0 WEIGHT AND BALANCE

Qty -041	Qty -043	Part Number	Description
X		D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X	D206-558-043	DUAL CARGO MIRROR ASSEMBLY
1	2	D3014-1	* LOCKNUT
1	1	D2071	CABLE ASSEMBLY
2	2	D2054	BUSHING
1	1	D2067	CONNECTOR
	1	D2066	ARM
1		D2065	ARM
1		D2057	PLUG
1	1	D2056	BELLCRANK ASSEMBLY
1	1	D2055	CLAMP
1	1	D2053	BRACKET
2	2	D2052	BRACKET
1	2	D2011-101	MIRROR ASSEMBLY
4	4	AN3-4A	BOLT
4	4	AN526-1032R9	SCREW
1	2	AN960JD416L	* WASHER
4	4	AN960JD10	WASHER
6	6	AN960JD10L	WASHER
3	3	MS21042-3	NUT (or MS21042L3)
2	2	MS21919DG5	CLAMP
2	2	MS27039-1-18	SCREW
1	1	MS35489-9	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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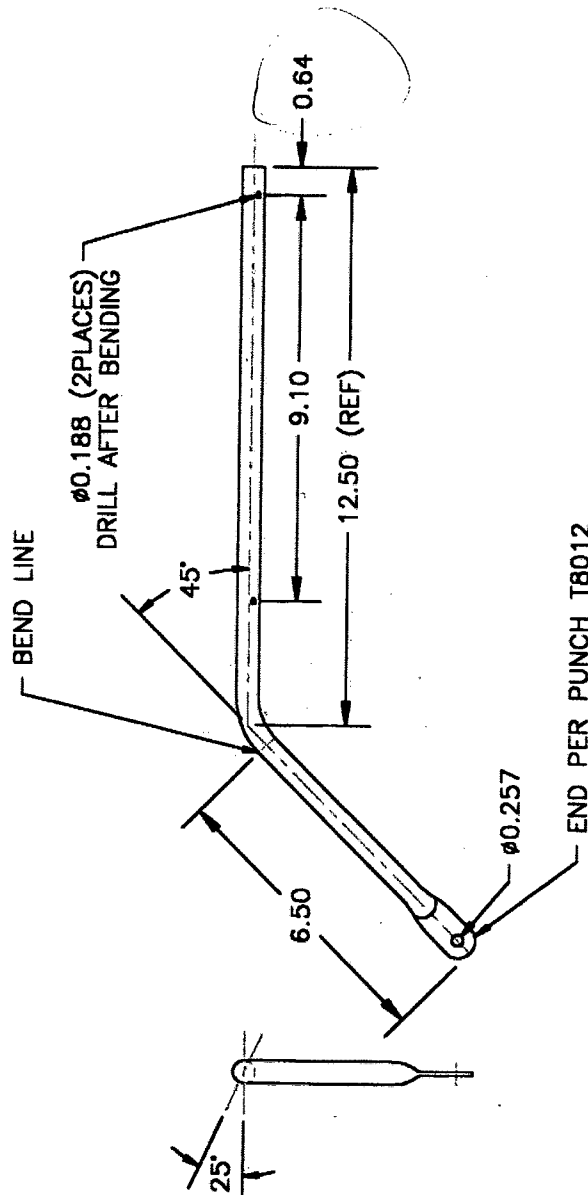
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96/11/14 BW

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B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2065	SHEET 1 OF 1
DATE	TITLE	ARM	SCALE
92.03.12			1:4
B	96.02.06	RE-DESIGN	
BI	02.03.25	ADD FINISH	



D2065 CUT LENGTH 19.5

MATERIAL: 304/316 SS 1/2 OD X 0.035 WALL
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART Q51 Q55 4.3 (31)

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